



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D350-591-312
Job Sheet 186597



Part No: D350-591-312

Job Qty: 10 ea

Part Name: Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/18/18

Job Tracking No: AIRBUS

Due Date: 1/25/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B IPP Rev:A 04.03.22 New issue KJ/RF IPP Rev:B 07-06-09 Added D3572-1 JLM IPP Rev:C 08-04-02 ECN1163 DD verified by:EC IPP Rev:D 08-04-08 ECN1164 DD verified by:eC IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea		1/25/19	0.00	0.00	Start Up Large Fab-4		SL4
110	Large Fab	10 pcs		1/25/19	0.00	10.00	Large Fab 2		SL4
120	QC	10 pcs		1/25/19	0.00	0.00	QC9		CPC
130	QC	10 pcs		1/25/19	0.00	0.00	QC5		CPC
140	HandFinish	10 pcs		1/25/19	0.00	1.87	HandFinish1		DR 18/12/20
150	QC	10 pcs		1/25/19	0.00	0.00	QC7-2		CPC
180	Large Fab	10 pcs		1/25/19	0.00	10.00	Large Fab 2		SL4
190	QC	10 pcs		1/25/19	0.00	0.00	QC10		38 DAS
200	QC	10 pcs		1/25/19	0.00	0.00	QC5		38
210	HandFinish	10 pcs		1/25/19	0.00	1.87	HandFinish1		DR 19/1/11
220	Powdercoat	10 pcs		1/25/19	0.00	2.98	Powdercoat1		8-89 38
230	HandFinish	10 pcs		1/25/19	0.00	1.87	HandFinish3		DR 19-01-14
240	QC	10 pcs		1/25/19	0.00	0.00	QC3		38
250	Packaging	10 pcs		1/25/19	0.00	0.00	Packaging1-3		68-6 9-89
260	QC	10 pcs		1/25/19	0.00	0.00	QC4		69 68-6
270	Packaging	10 pcs		1/25/19	0.00	0.00	Packaging3-1		69
275	DC	10 pcs		1/25/19	0.00	0.00	DC		21
280	QC21-FG	10 Ea		1/25/19	0.00	0.00	QC21		21

Part Op 110 - 1-Bevel end for welding FWD ONLY 2-Weld Support using Jig DT10115, weld Fwd End Plate as per QSI 004 & Descriptions: Dwg D3272 A/R Aluminum Rod M134785 3-Grind End Plate flush

180 - 1-Assemble Leg Assembly as per Dwg D3272. 2-Leave one rivet out until welding is complete. 3-Bevel Aft end for welding 4-Inspect for foreign object as per QSI 024 5-Weld Aft End Plate as per QSI 004 & Dwg D3272 A/R Aluminum Rod 6-Grind End Plate flush 7-Install last rivet as per Dwg.

220 - START TIME: 7:50 OVEN TEMPERATURE: 520 FINISH TIME: 8:20

270 - Identify and pack for shipping as per PPPD350-591-312 Location FG109

275 - Photocopy bluefile and type labels as per PPP D350-591-312 CHG001

M138997

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3067-1	End Plate	20 Ea (2 ea)	90-Start up Operation	8125543
D3219-1	Plate	20 Ea (2 ea)	90-Start up Operation	8125734
D3272-1	Step	10 Ea (1 ea)	90-Start up Operation	8136614

6997

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

D3065-041	Step Leg Assembly	10 Ea (1 ea)	180-Large Fab
D3066-1	Spacer	20 Ea (2 ea)	180-Large Fab
MS20600-AD4W4	Rivet	160 Ea (16 ea)	180-Large Fab
AN3-35A	Bolt	20 Ea (2 ea)	250-Packaging
AN4-13A	Bolt	80 Ea (8 ea)	250-Packaging
AN5-36A	Bolt	20 Ea (2 ea)	250-Packaging
D2230-3	Mounting Lug	40 Ea (4 ea)	250-Packaging
D2618	Bushing	20 Ea (2 ea)	250-Packaging
D2856-400-720	Abrasion Strip 4" X 7.20"	20 Ea (2 ea)	250-Packaging
D3235-1	Mounting Lug	20 Ea (2 ea)	250-Packaging
D3278-041	Support Assembly	10 Ea (1 ea)	250-Packaging
MS21042L3	Nut	20 Ea (2 ea)	250-Packaging
MS21042L4	Nut	80 Ea (8 ea)	250-Packaging
MS21042L5	Nut	20 Ea (2 ea)	250-Packaging
NAS1149D0363J	Washer	40 Ea (4 ea)	250-Packaging
NAS1149D0463J	Washer	160 Ea (16 ea)	250-Packaging
NAS1149D0563J	Washer	40 Ea (4 ea)	250-Packaging

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5128757
117999

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D3067-1	20	260	0
	D3219-1	20	219	0
	D3272-1	10	1	0
180-Large Fab	D3065-041	10	21	0
	D3066-1	20	350	0
	MS20600-AD4W4	160	2,558	0
250-Packaging	AN3-35A	20	253	0
	AN4-13A	80	950	0
	AN5-36A	20	116	0
	D2230-3	40	68	0
	D2618	20	169	0
	D2856-400-720	20	186	0
	D3235-1	20	109	0
	D3278-041	10	43	0
	MS21042L3	20	1,721	0
	MS21042L4	80	1,882	0
	MS21042L5	20	423	0
	NAS1149D0363J	40	2,068	0
	NAS1149D0463J	160	2,662	0
	NAS1149D0563J	40	1,308	0

Part Specifications

Specifications could not be found.

7368

Plex 11/19/18 8:38 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐			
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																				
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																				
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Large Fab ☐	Composite ☐	Supplier ☐																					
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval																			
Description Work Order Deviation		Disposition		Completed By																			
1270 Aberdeen Street Newbury, ON K6A 1K7 CANADA TEL: 1-513-892-6200 Email: sales@dartaero.com www.dartaerospace.com Container No: S136660 Part: D350 - 591 - 312 Job No: 186597 Serial No/Batch: S136660 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: TC STC SH92 - 6 Issue 1d, FAA STC SH967NE 04/12/21, BRAZIL 1				Lead hand / Supervisor Approval Verification																			
				QC / QA Coordinator Approval																			
FAULT CATEGORY <table style="width:100%; border: none;"> <tr> <td style="border: none;">☐ Power Loss/Surge</td> <td style="border: none;">☐ Positioned Wrong</td> </tr> <tr> <td style="border: none;">☐ Folio/Program</td> <td style="border: none;">☐ Outside Dimensions</td> </tr> <tr> <td style="border: none;">☐ Grain</td> <td style="border: none;">☐ Over/Under tolerance</td> </tr> <tr> <td style="border: none;">☐ Weld</td> <td style="border: none;">☐ Part Incorrect</td> </tr> <tr> <td style="border: none;">☐ Wrong Stock Pulled</td> <td style="border: none;">☐ Part Lost/Missing</td> </tr> <tr> <td style="border: none;">☐ Out of Sequence</td> <td style="border: none;">☐ Part Moved</td> </tr> <tr> <td style="border: none;">☐ Off-set</td> <td style="border: none;">☐ Drawing</td> </tr> <tr> <td style="border: none;">☐ Mislabeled</td> <td style="border: none;">☐ Finish</td> </tr> <tr> <td style="border: none;">☐ Fit/Function</td> <td style="border: none;">☐ Misread</td> </tr> <tr> <td style="border: none;">☐ Misaligned/off center</td> <td style="border: none;">☐ Turning Sequence</td> </tr> </table>		☐ Power Loss/Surge	☐ Positioned Wrong	☐ Folio/Program	☐ Outside Dimensions	☐ Grain	☐ Over/Under tolerance	☐ Weld	☐ Part Incorrect	☐ Wrong Stock Pulled	☐ Part Lost/Missing	☐ Out of Sequence	☐ Part Moved	☐ Off-set	☐ Drawing	☐ Mislabeled	☐ Finish	☐ Fit/Function	☐ Misread	☐ Misaligned/off center	☐ Turning Sequence		
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D350-591-312
Job Sheet 186597



Part No: D350-591-312

Job Qty: 10 ea

Part Name: Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/18/18

Job Tracking No: AIRBUS

Due Date: 1/25/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B IPP Rev:A 04.03.22 New issue KJ/RF IPP Rev:B 07-06-09 Added D3572-1 JLM IPP Rev:C 08-04-02 ECN1163 DD verified by:EC IPP Rev:D 08-04-08 ECN1164 DD verified by:eC IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea		1/25/19	0.00	0.00	Start Up Large Fab-4		SLU
110	Large Fab	10 pcs		1/25/19	0.00	10.00	Large Fab 2		SLU
120	QC	10 pcs		1/25/19	0.00	0.00	QC9		CPC
130	QC	10 pcs		1/25/19	0.00	0.00	QC5		CPC
140	HandFinish	10 pcs		1/25/19	0.00	1.87	HandFinish1		PR 18/12/20
150	QC	10 pcs		1/25/19	0.00	0.00	QC7-2		CPC
180	Large Fab	10 pcs		1/25/19	0.00	10.00	Large Fab 2		SLU
190	QC	10 pcs		1/25/19	0.00	0.00	QC10		
200	QC	10 pcs		1/25/19	0.00	0.00	QC5		
210	HandFinish	10 pcs		1/25/19	0.00	1.87	HandFinish1		
220	Powdercoat	10 pcs		1/25/19	0.00	2.98	Powdercoat1		
230	HandFinish	10 pcs		1/25/19	0.00	1.87	HandFinish3		
240	QC	10 pcs		1/25/19	0.00	0.00	QC3		JAN 10 2019
250	Packaging	10 pcs		1/25/19	0.00	0.00	Packaging1-3		
260	QC	10 pcs		1/25/19	0.00	0.00	QC4		
270	Packaging	10 pcs		1/25/19	0.00	0.00	Packaging3-1		
275	DC	10 pcs		1/25/19	0.00	0.00	DC		
280	QC21-FG	10 Ea		1/25/19	0.00	0.00	QC21		

Part Op 110 - 1-Bevel end for welding FWD ONLY 2-Weld Support using Jig DT10115, weld Fwd End Plate as per QSI 004 & Descriptions: Dwg D3272 A/R Aluminum Rod M134785 3-Grind End Plate flush

180 - 1-Assemble Leg Assembly as per Dwg D3272. 2-Leave one rivet out until welding is complete. 3-Bevel Aft end for welding 4-Inspect for foreign object as per QSI 024 5-Weld Aft End Plate as per QSI 004 & Dwg D3272 A/R Aluminum Rod 6-Grind End Plate flush 7-Install last rivet as per Dwg.

220 - START TIME: OVEN TEMPERATURE: FINISH TIME:

270 - Identify and pack for shipping as per PPPD350-591-312 Location FG109

275 - Photocopy bluefile and type labels as per PPP D350-591-312 CHG001

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3067-1	End Plate	20 Ea (2 ea)	90-Start up Operation	3125543
D3219-1	Plate	20 Ea (2 ea)	90-Start up Operation	3125734
D3272-1	Step	10 Ea (1 ea)	90-Start up Operation	3136614

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Job 186592 007399

D3065-041	Step Leg Assembly	10 Ea (1 ea)	180-Large Fab
D3066-1	Spacer	20 Ea (2 ea)	180-Large Fab
MS20600-AD4W4	Rivet	160 Ea (16 ea)	180-Large Fab
AN3-35A	Bolt	20 Ea (2 ea)	250-Packaging
AN4-13A	Bolt	80 Ea (8 ea)	250-Packaging
AN5-36A	Bolt	20 Ea (2 ea)	250-Packaging
D2230-3	Mounting Lug	40 Ea (4 ea)	250-Packaging
D2618	Bushing	20 Ea (2 ea)	250-Packaging
D2856-400-720	Abrasion Strip 4" X 7.20"	20 Ea (2 ea)	250-Packaging
D3235-1	Mounting Lug	20 Ea (2 ea)	250-Packaging
D3278-041	Support Assembly	10 Ea (1 ea)	250-Packaging
MS21042L3	Nut	20 Ea (2 ea)	250-Packaging
MS21042L4	Nut	80 Ea (8 ea)	250-Packaging
MS21042L5	Nut	20 Ea (2 ea)	250-Packaging
NAS1149D0363J	Washer	40 Ea (4 ea)	250-Packaging
NAS1149D0463J	Washer	160 Ea (16 ea)	250-Packaging
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5136112
5132364
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5093592
5107782
5129985
5050053

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D3067-1	20	260	0
	D3219-1	20	219	0
	D3272-1	10	1	0
180-Large Fab	D3065-041	10	21	0
	D3066-1	20	350	0
	MS20600-AD4W4	160	2,558	0
250-Packaging	AN3-35A	20	253	0
	AN4-13A	80	950	0
	AN5-36A	20	116	0
	D2230-3	40	68	0
	D2618	20	169	0
	D2856-400-720	20	186	0
	D3235-1	20	109	0
	D3278-041	10	43	0
	MS21042L3	20	1,721	0
	MS21042L4	80	1,882	0
	MS21042L5	20	423	0
	NAS1149D0363J	40	2,068	0
	NAS1149D0463J	160	2,662	0
	NAS1149D0563J	40	1,308	0

Part Specifications

Specifications could not be found.